



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D3913-041
Job Sheet 188551



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	2/1/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		LL
							Large Fab - 8		
110	QC 9	1 pcs	2/1/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		SH
							QC 9 - 50		
120	QC 5	1 pcs	2/1/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		SH
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
125	Handfinish - 2-1 Pressure- B4B	1	2/1/19	0.00 0.29	Handfinish - 2 - 1 - B4B
	pcs				Handfinish - 2 - 2 - B4B
					Handfinish - 2 - 3 - B4B
130	Powdercoat - 2 White Gl(S)- B4B	1	2/1/19	0.00 0.93	Powdercoat - 1 - B4B
	pcs				Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
135	Packaging 1-1 - Pick Kit - B4B	1	2/1/19	0.00 0.00	Packaging 1 - 1 - B4B
	pcs				Packaging 1 - 2 - B4B
					Packaging 1 - 3 - B4B
					Packaging 1 - 4 - B4B
					Packaging 1 - 5 - B4B
					Packaging 1 - 6 - B4B
					Packaging 1 - 7 - B4B
					Packaging 1 - 8 - B4B
					Packaging 1 - 9 - B4B
					Packaging 1 - 10 - B4B
					Packaging 1 - 11 - B4B
					Packaging 1 - 12 - B4B
					Packaging 1 - 13 - B4B
					Packaging 1 - 14 - B4B
					Packaging 1 - 15 - B4B
					Packaging 1 - 16 - B4B
					Packaging 1 - 17 - B4B
					Packaging 1 - 18 - B4B
					Packaging 1 - 19 - B4B
					Packaging 1 - 20 - B4B
					Packaging 1 - 21 - B4B
					Packaging 1 - 22 - B4B
					Packaging 1 - 23 - B4B
					Packaging 1 - 24 - B4B
					Packaging 1 - 25 - B4B
					Packaging 1 - 26 - B4B
					Packaging 1 - 27 - B4B
					Packaging 1 - 28 - B4B
					Packaging 1 - 29 - B4B
					Packaging 1 - 30 - B4B
					Packaging 1 - 31 - B4B
					Packaging 1 - 32 - B4B
					Packaging 1 - 33 - B4B
					Packaging 1 - 34 - B4B
					Packaging 1 - 35 - B4B
					Packaging 1 - 36 - B4B
140	QC 3	1	2/1/19	0.00 0.00	QC 3 - 10
	pcs				QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36

BR 19-02-21

BR 19-02-21

BR 19-02-21

START: 1:15 O.I. 375° FINISH: 1:30.
M138947

			QC 3 - 38	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	BE B19-02-21
			QC 3 - 6	
			QC 3 - 68	
			QC 3 - 9	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	2/1/19	0.00 0.50
			Handfinish - 4 - 1 - B4B	
			Handfinish - 4 - 10 - B4B	BE B19-02-21
			Handfinish - 4 - 11 - B4B	
			Handfinish - 4 - 12 - B4B	
			Handfinish - 4 - 13 - B4B	
			Handfinish - 4 - 14 - B4B	
			Handfinish - 4 - 15 - B4B	
			Handfinish - 4 - 2 - B4B	
			Handfinish - 4 - 3 - B4B	
			Handfinish - 4 - 4 - B4B	
			Handfinish - 4 - 5 - B4B	
			Handfinish - 4 - 6 - B4B	
			Handfinish - 4 - 7 - B4B	
			Handfinish - 4 - 8 - B4B	
			Handfinish - 4 - 9 - B4B	
160	QC 5	1 pcs	2/1/19	0.00 0.00
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 38	
			QC 5 - 42	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	DAS
			QC 5 - 68	FEB 21 2019 68
			QC 5 - 9	9-89
			QC 5 - 50	
			QC 5 - 30	
170	Packaging 3-1 - Stock - B4B	1 pcs	2/1/19	0.00 0.00
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Plex 2/4/19 4:44 PM Dart.Hadley.Shannon	

					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	BEB19-02-21
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA					QC 21 - SA - 21	DAC
1					QC 21 - SA - 70	21
pcs					QC 21 - SA - 53	2-26
2/1/19						FEB 21 2019
0.00 0.00						
Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ****take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg 110 - QC9- Inspect visual per QSI004- Fusion Welds 120 - QC5- Inspect part completeness to step on W/O 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat 135 - Pick Kit 140 - QC3- Inspect Part Finish 150 - Assemble as per dwg - Pick Kit 160 - QC5- Inspect part completeness to step on W/O 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5146653
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5151924
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5143390
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5151701
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5150514
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5148608
D3916-041	Rib Assembly	2 Ea (2 ea)	100-Large Fab - Basket - 1	5152381
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5151590
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5115309
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5150132
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5150532
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5149407
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5143400
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5153858
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5152401
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5145300
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	100-Large Fab - Basket - 1	5125258
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5132304-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5186435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5076007
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5094592
NAS1149F0332P	Washer	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5134693-1
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5144379
NAS1149FN832P	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368-1

M.U. 008262

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	77	0
	D3913-1	1	6	0
	D3913-15	1	18	0
	D3913-3	1	6	0
	D3913-7	2	14	0
	D3913-9	1	11	0
	D3916-041	2	10	0
	D3916-5	3	18	0
	D4016-1	3	147	0
	D4017-7	3	34	0
	D4017-9	2	24	0
	D4020-11	2	32	0
	D4021-1	3	59	0
	D4034-041	1	5	0
	D4034-043	1	4	0
	D4672-1	2	38	0
	M304EX0.75-16F	33	2,080	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	235	0
	D2931	2	815	0
	D4021-5	2	38	0
	MS20600-AD4W3	2	147	0
	MS21042L3	6	2,782	0
	NAS1149F0332P	12	3,048	0
	NAS1149FN832P	2	3,162	0

Part Specifications

Specifications could not be found.



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D3913-041
Job Sheet 188551



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/10/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/1/19	0.00	0.00	Start Up Large Fab-5		
100	Large Fab	1 pcs		2/1/19	0.00	10.00	Large Fab 1		
110	QC	1 pcs		2/1/19	0.00	0.00	QC9		
120	QC	1 pcs		2/1/19	0.00	0.00	QC5		
125	HandFinish	1 pcs		2/1/19	0.00	0.29	HandFinish2		
130	Powdercoat	1 pcs		2/1/19	0.00	0.93	Powdercoat2		
135	Packaging	1 pcs		2/1/19	0.00	0.00	Packaging1		
140	QC	1 pcs		2/1/19	0.00	0.00	QC3		
150	HandFinish	1 pcs		2/1/19	0.00	0.50	HandFinish4		
160	QC	1 pcs		2/1/19	0.00	0.00	QC5		
170	Packaging	1 pcs		2/1/19	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea		2/1/19	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	90-Start up Operation	
D3913-1	Rib	1 pcs (1 ea)	90-Start up Operation	
D3913-15	Wide Handle Plate	1 pcs (1 ea)	90-Start up Operation	
D3913-3	Rib	1 pcs (1 ea)	90-Start up Operation	
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	
D4016-1	Hinge Half, Base	3 pcs (3 ea)	90-Start up Operation	
D4017-7	Rib	3 pcs (3 ea)	90-Start up Operation	
D4017-9	Rib	2 pcs (2 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval ☐		
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								OTHER : _____																																							

D4020-71	End Mesh, Basket	2 pcs (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 pcs (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 pcs (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 pcs (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 pcs (2 ea)	150-HandFinish
NAS1149FN832P	Washer	2 Ea (2 ea)	150-HandFinish

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	67	0
	D3913-1	1	5	0
	D3913-15	1	25	0
	D3913-3	1	4	0
	D3913-7	2	16	0
	D3913-9	1	4	0
	D3916-041	2	2	0
	D3916-5	3	7	0
	D4016-1	3	168	0
	D4017-7	3	35	0
	D4017-9	2	10	0
	D4020-11	2	1	0
	D4021-1	3	50	0
	D4034-041	1	8	0
	D4034-043	1	7	0
	D4672-1	2	2	0
	M304EX0.75-16F	33	1,402	0
150-HandFinish	AN3-10A	6	207	0
	D2931	2	831	0
	D4021-5	2	3	0
	MS20600-AD4W3	2	243	0
	MS21042L3	6	2,377	0
	NAS1149F0332P	12	2,468	0
	NAS1149FN832P	2	3,391	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work C

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT	
	Rework	☐	Skid-tube	☐
Part No. _____	Scrap	☐	Machining	☐
	Use-as-is	☐	Thermoforming	☐
NCR No. _____	Suspected Unapproved	☐	Large Fab	☐
			Cross tube	☐
			Small Fab	☐
			Finishing	☐
			Composite	☐

Date :	Step #:	QTY Effective :
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Description Work Order Deviation	Disposition

Root Cause			FAULT CATEGORY					
Environment		No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong		
Design		Operator	Bending	Set-up	Folio/Program	Outside Dimensions		
Doc/Data		Offset/Set-up	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance		
Equip/Tooling		Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect		
Handling/Pre		Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing		
Material		Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved		
Internal Transport		Poor Information	Crushing	Countersink	Off-set	Drawing		
Tribal Knowledge		Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish		
LOA		Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread		
Substation		Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence		
Past Expiry Date		Manufacturing Process						
Misidentified		Past Due	OTHER :					

Part: D3913-041
Job No: 188551
Serial No/Batch: S154153
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 02/15/19

Container No: S154153

**1270 Aberdeen Street
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Email: sales@dartero.com
www.darterospace.com**

proval

Supervisor
ation

**QC / QA Coordinator
Approval**